

Work Order ID 72140

Tuesday, July 19, 2011 12:48:24 PM



Page 1

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 7/19/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 7-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2654

Rev E1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654 □2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 □3-Using the uni-bit, open holes to finish size as per Dwg D2654 □4-Deburr holes and ends

[Handwritten mark]

[Signature]
11/07/19

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

3 0 BE 11/07/19

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3 *[Signature]*
11/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72140

Tuesday, July 19, 2011 12:48:24 PM



Page 2

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 7/19/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-7-20

140

Identify as per dwg & Stock Location:

46

0.00



Packaging

Memo

0.00

Packaging

11-7-20

3

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
11-07-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 12:48:30 PM

Work Order ID: 72140



Parent Item: D2654-5



Parent Item Name: Web

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-7-140

Manufactured

No

100

Each

6.0000

1

3



EXT. "I BEAM" THICK

Location

Loc Qty

Loc Code

LG

41591

6

6

3

u/02/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






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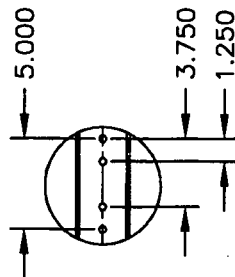
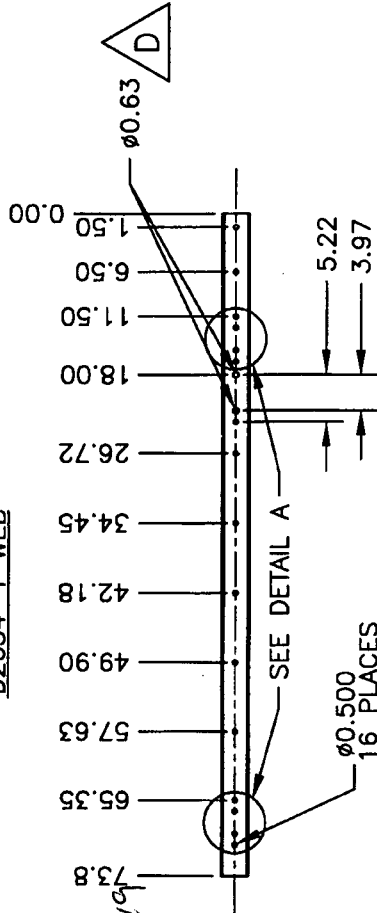
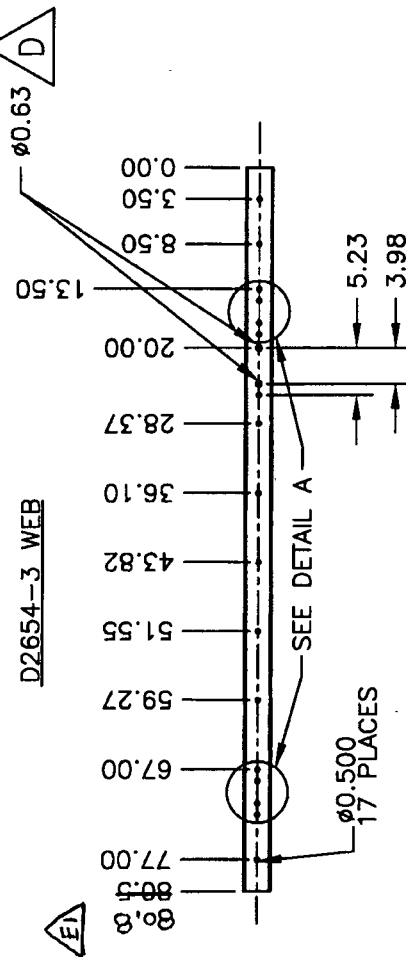
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**DEO ATTACHED****RELEASED**
04.06.22

DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2654	
DATE 04.05.26		TITLE WEB		REV. E SHEET 1 OF 2	
		SCALE 1:20			
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO Ø0.63			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	 04.08.04	PER TOOLING; 80.8 WAS 80.5			

D2654-1 WEBDETAIL A
SCALE 1:10**D2654-3 WEB**MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

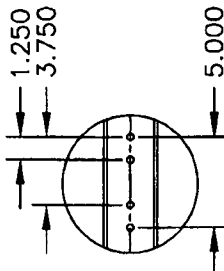


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

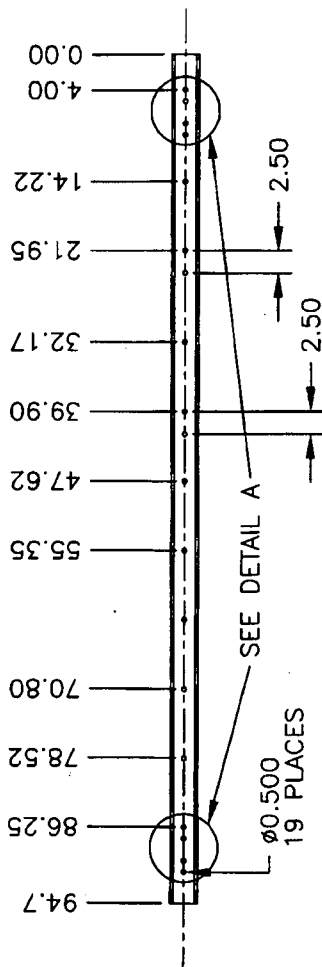
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04.06.22

DEO ATTACHED

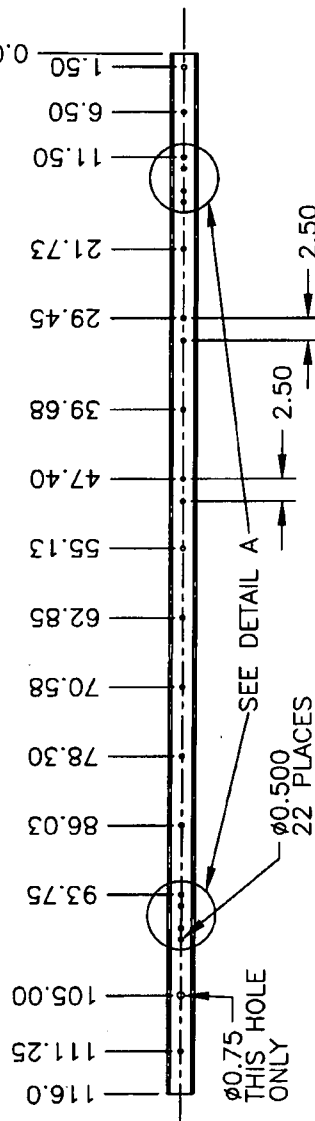
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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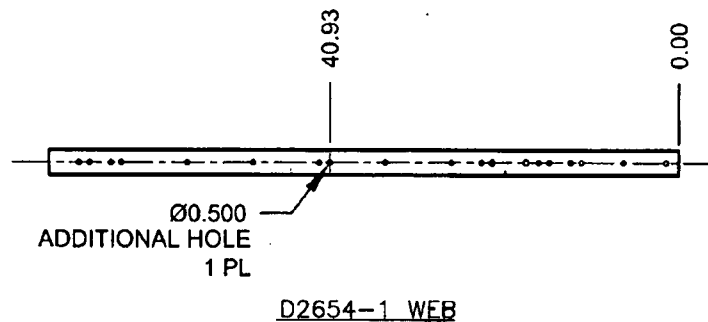
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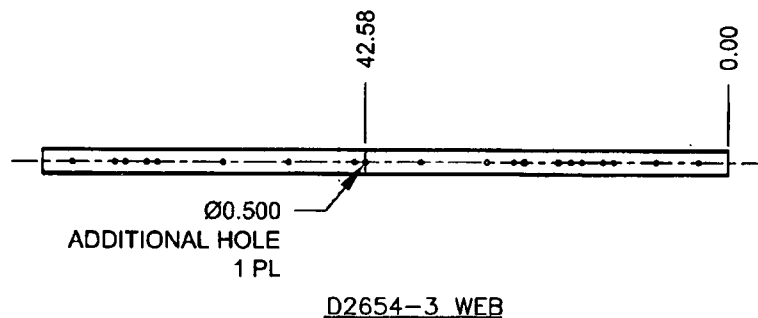
DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>LP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03		DATE 09.04.03		

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MD*



72140



THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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